

ASAP

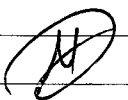
Work Order ID: 129496

129496

Page 1

Thursday, February 12, 2015 9:24:39 AM

Item ID: D3806-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 2/13/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 2/26/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan:  Date: 15.2.12 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00
 100
 Cold Saw
 Hyd Mech
 Memo
 Cut blanks at 44.50"
 FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING
 10 1502-19
 DAS 20 9-89

110 0.00
 110
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 1-Mill as per folio FB070 & dwg
 FOLIO REV: B
 DWG REV: B
 2-Deburr as required
 10 15/02/19
 DAS 44 9-89

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Page 2

[illegible]

Work Order ID 129496***129496***

Page 3

Thursday, February 12, 2015 9:24:39 AM

Item ID: D3806-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 2/13/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/26/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

15/2/23

AS223

Picklist Print

Thursday, February 12, 2015 9:24:44 AM

Page 1

Work Order ID: 129496

129496

Parent Item: D3806-5

D3806-5

Parent Item Name: Bar

Start Date: 2/13/15

Required Date: 2/26/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
IPP Rev:B 08-09-23 redesign DD verified by:EC
IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased		No			f	216.4160		40			DAS
M304B0 250x0 500									**	49.500'			20 9-89 1502-19
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT009

216.416

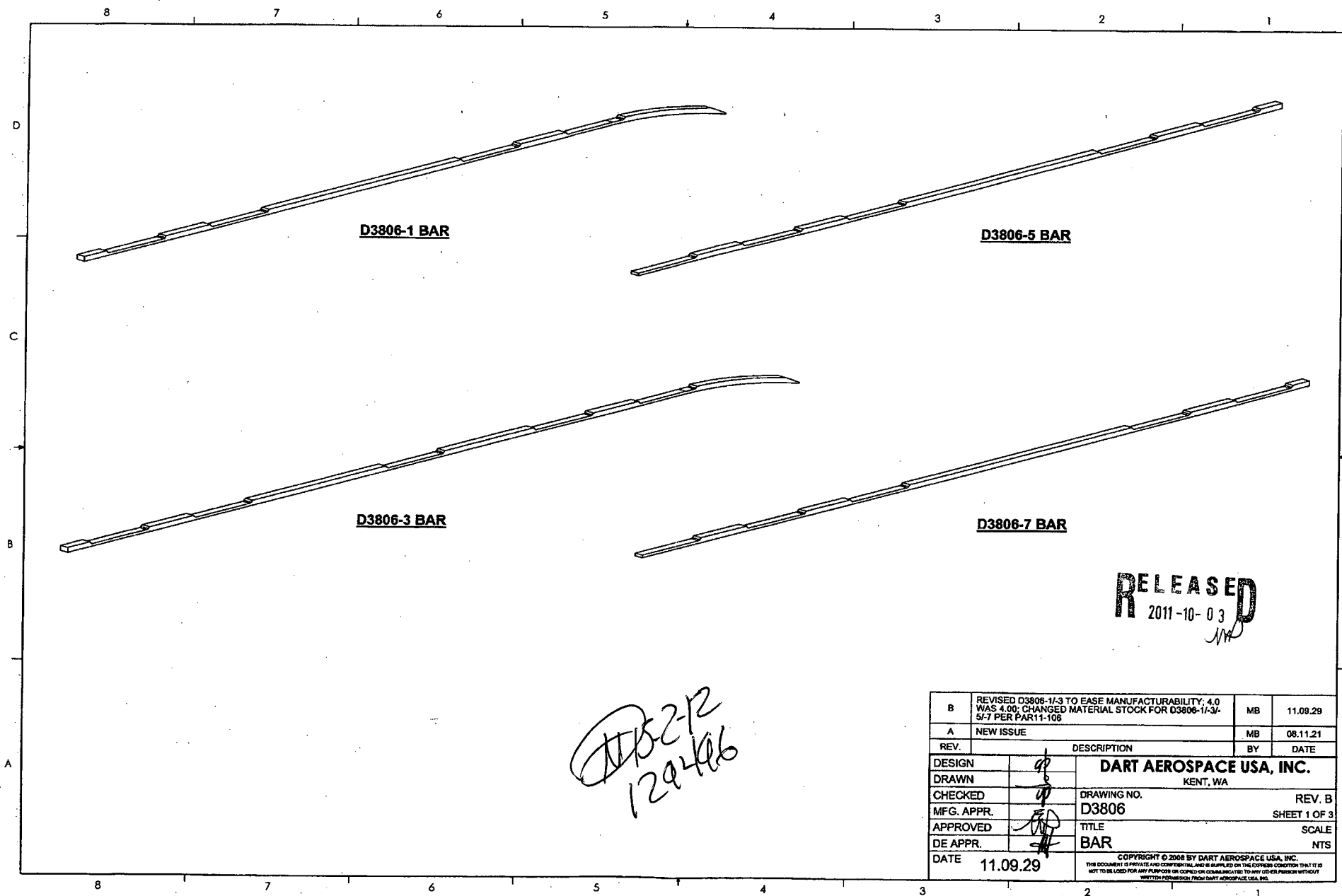
m129366

32.316

m131205

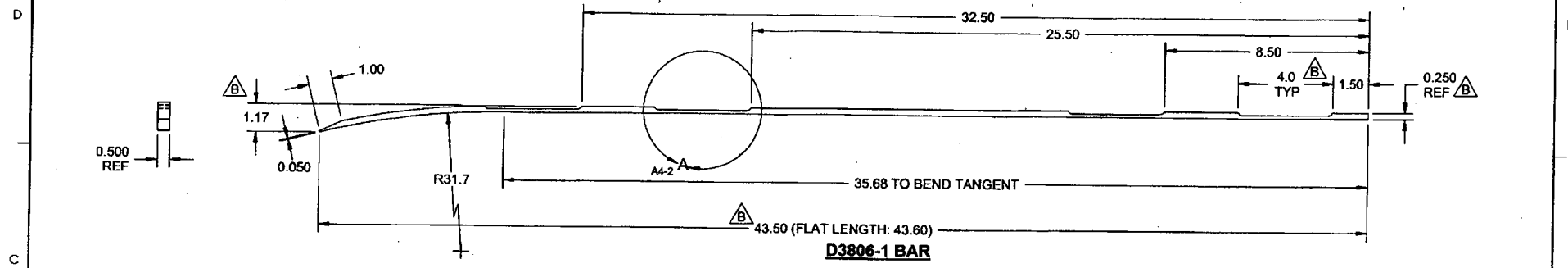
184.1

49.500'

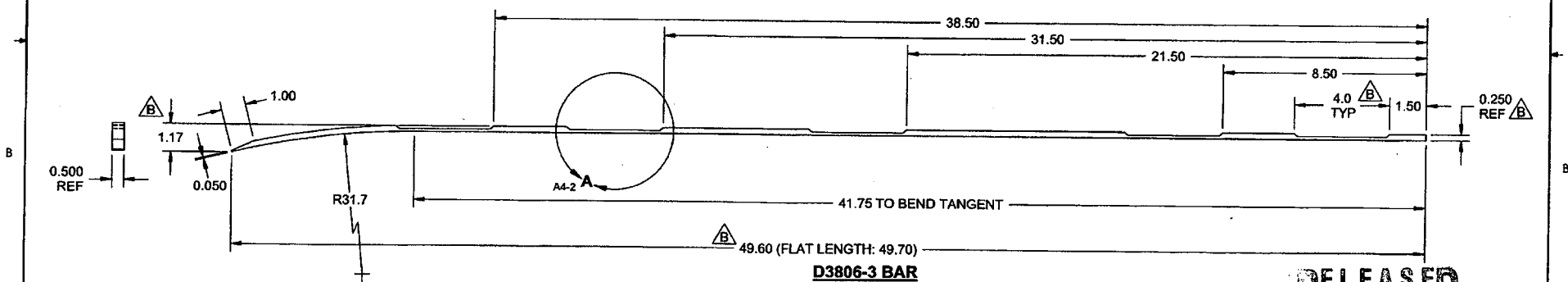


B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY. 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PAR11-108		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC. KENT, WA		REV. B	
DRAWN			SHEET 1 OF 3	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED	DRAWING NO. D3806		TITLE	
DE APPR.	BAR		DATE	
DATE	11.09.29		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



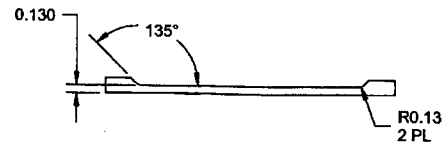
D3806-1 BAR



D3806-3 BAR

RELEASED
2011-10-03

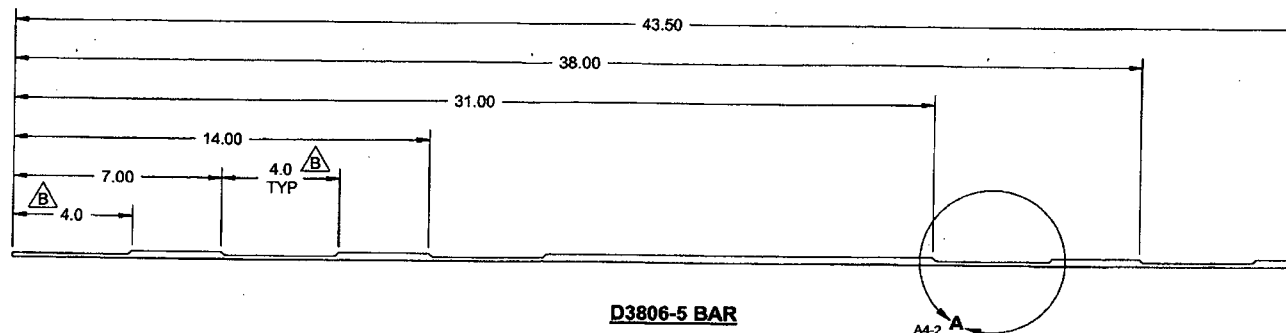
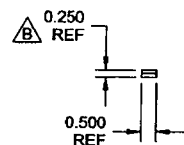
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



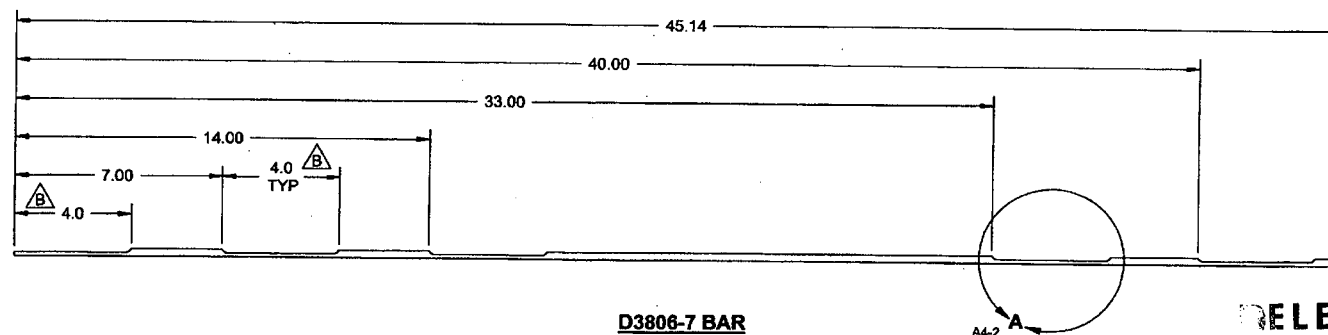
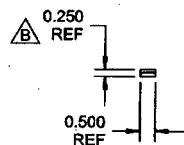
DETAIL A
TYP, SCALE 2X

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3806	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAR	NTS
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8 7 6 5 4 3 2 1



D3806-5 BAR



D3806-7 BAR

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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